

Work Order ID 132103

Friday, April 24, 2015 2:22:19 PM

132103

Page 1

Item ID: D206-628-024RLC

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/27/15 Req'd Qty: 1.00 ***1***

Customer:

Reference: *Rework*

Approvals: Process Plan: *[Signature]* Date: *15-4-24*

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

110 Pick Kit 0.00

110

Packaging

Packaging

Memo

PULL FROM STOCK
D206-628-024 B:109616

REMOVE THESE ITEM:

AN3C4A (3)
D2844-1 (2)
D2844-3 (1)
NAS1149C0363R (3)

REPACKAGE AS:

D206-628-024RLC
CHANGE LABLES.

0.00

DAS

06

9-89

APR 27 2015

DAS		PATENT N/A	
P/N	D206-628-024	CHG	CHG003
DESC	Heli-Access-Step RH	STC	SH98-14
LOT	B109616	STC	SA00500SE
MODEL	206L/L1/L3/L4	STC	
TO APPROVAL 2-08-89		MADE IN CANADA	

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Quality Control

Memo

0.00

DAS

38

9-89

15-04-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 132103

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132103

Page 2

Item ID: D206-628-024RLC Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4
Start Date: 4/24/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/27/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-024								
	Location: _____								
	PPP Rev: _____								
	<i>Ship off shore</i>								
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MS 1504-23

MS-4-24

MS 86 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 132103

132103

Parent Item: D206-628-024RLC

D206-628-024RI C

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.23 NEW ISSUE LL VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased		No			Each	837.0000		-3			
--------	--	-----------	--	----	--	--	------	----------	--	----	--	--	--

AN3C4A

Bolt

**

DAS
06
9-89

Location

Loc Qty

Loc Code

FG	20	
122814	20	
FP001	6	
M131803	6	
ST338a	4	
M131320	4	
ST350	807	
M131420	807	

125388
125388

D206-628-024

Manufactured No

D206-628-024

Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

**

DAS
06
9-89

Location

Loc Qty

Loc Code

FG	2	
109616	1	
97614	1	
FG081	1	
109616	1	

1

D2844-1

Manufactured No

D2844-1

Arm

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST352	8	
125358	1	
129576	7	

-2

108870

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Work Order ID: 132103

132103

Parent Item: D206-628-024RLC

D206-628-024RI C

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

D2844-3

Manufactured No

Each

0.0000

-1

D2844-3

Arm

NAS1149C0363R

Purchased No

Each

468.0000

-3

NAS1149C0363R

Washer

Location

Loc Qty

Loc Code

FP001

75

114742

75

GA

181

m130673

181

ST271

212

m130673

212

AN4C14A

Purchased No

120

Each

113.0000

4

4

AN4C14A

Bolt

Location

Loc Qty

Loc Code

FG

25

118706

20

123021

5

ST312A

50

131677

50

ST344

38

m130716

13

m131452

25

**

98949

DAS

05

9-89

**

122441

DAS

05

9-89

**

80

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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☐ OTHER : _____					

Picklist Print

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Work Order ID: 132103

132103

Parent Item: D206-628-024RLC

D206-628-024RI C

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

AN4C15A

Purchased

No

120

Each

77.0000

8

8

AN4C15A

Bolt

**

50

Location

Loc Qty

Loc Code

FG

10

120360

10

ST343

67

M130716

50

M131377

17

D2731-7

Manufactured

No

120

Each

60.0000

4

4

D2731-7

Mounting Lug

**

50

Location

Loc Qty

Loc Code

ST520

36

116802

36

ST532A

24

129255

24

D2732

Manufactured

No

120

f

629.5000

2

2

D2732

Rubber Cushion (\$per foot)

**

30

Location

Loc Qty

Loc Code

ST412

420.5

117118

420.5

ST639

209

117118

209

(D2732-030) Cut (8) at 3.00"

D2842-042

Manufactured

No

120

Each

0.0000

1

1

D2842-042

Step Assembly, RH, 206 Float

**

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Work Order ID: 132103

132103

Parent Item: D206-628-024RLC

D206-628-024RI C

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

D3394-043

Manufactured No

120 Each

9.0000

4 4

D3394-043

Lug

**

50

Location

Loc Qty

Loc Code

ST528

9

124220

9

MS21043-4

Purchased No

120 Each

1,079.000

12 12

MS21043-4

Nut

**

30

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

367

m128798

367

ST304

672

m128818

34

m131697

638

NAS1149C0432R

Purchased No

120 Each

3,543.000

24 24

NAS1149C0432R

WASHER

**

50

Location

Loc Qty

Loc Code

GA

2206

m125807

476

m131467

1730

ST271

1337

m131452

1337

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID: 132103

132103

Parent Item: D206-628-024RLC

D206-628-024RI C

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased No

120

Each

555.0000

3

3

NAS1515H3

Washer

SP

Location

Loc Qty

Loc Code

FG	10
123301	10
GA	44
m129521	44
ST266	501
m128635	13
m131697	488

120

Each

337.0000

21

21

SP

NAS1515H4L

Purchased No

***NAS1515H4I ***

Washer

Location

Loc Qty

Loc Code

FG	2
103691	2
ST260a	335
m131026	96
m131624	8
m131697	231

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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